



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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SWA3-400  
Job Sheet 187269



Part No: SWA3-400

Job Qty: 20 ea

Part Name: Button Head Screw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-400 Rev 3 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 20 Ea  |            | 12/14/18 | 0.00      | 0.00    | Start Up Machining-2  |           |          |
| 110   | Lathe Conv         | 20 pcs |            | 12/14/18 | 0.00      | 5.00    | Conv-1 Lathe          |           |          |
| 120   | QC                 | 20 pcs |            | 12/14/18 | 0.00      | 0.00    | QC2 Machining-4       |           |          |
| 130   | QC                 | 20 pcs |            | 12/14/18 | 0.00      | 0.00    | QC8 Machining-4       |           |          |
| 140   | Packaging          | 20 pcs |            | 12/14/18 | 0.00      | 0.00    | Packaging3-1          |           |          |
| 150   | QC21-SA            | 20 Ea  |            | 12/14/18 | 0.00      | 0.00    | QC21                  |           |          |

Part Op Descriptions: 110 - 1-Machine as per DWG. (Machine to length) DWG REV: \_\_\_\_\_ 2-Deburr

DEC 04 2018  
21  
9-89

### Job BOM

| Part / Item | Component Name             | Quantity     | Operation             | Container        |
|-------------|----------------------------|--------------|-----------------------|------------------|
| 92949A595   | SS Button Head Drive Screw | 20 Ea (1 ea) | 90-Start up Operation | 5097689<br>GA055 |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | 92949A595      | 20       | 70        | 0         |

### Part Specifications

Specifications could not be found.



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Plex 11/29/18 12:39 PM Dart.lajeunesse.marie

Container No: S133901



Part: SWA3-400

Job No: 187269

Serial No/Batch: S133901

Revision: 3

Inspector:

Exp Date:

Instructions: IPP Rev A 17.12.18 New issue DD Verify DD



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                               |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div> |  |                               |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | MRB (QSI042)                  |  |
| <b>Description Work Order Deviation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | <b>Disposition</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | <b>Completed By</b>           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | <b>Lead hand / Supervisor</b> |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                               |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | <b>QC / QA Coordinator</b>    |  |
| <b>Root Cause</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Presservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                                                                                                                                   | <b>Other/Details:</b><br><br><div style="height: 100px;"></div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                               |  |

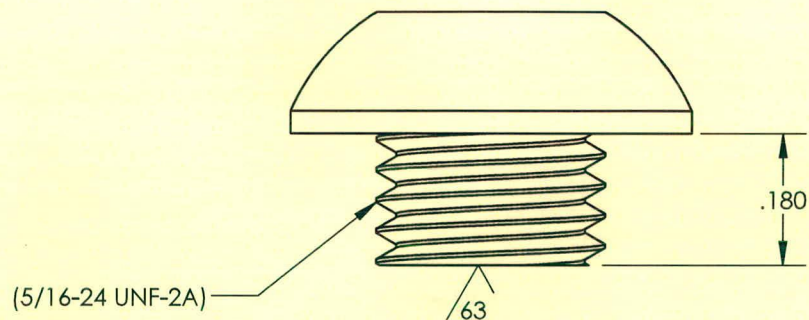
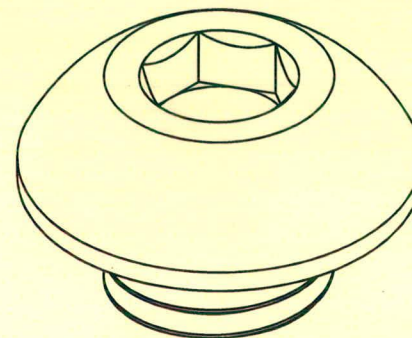






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| REVISIONS |         |                                                                                             |           |         |          |
|-----------|---------|---------------------------------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                                 | DATE      | INITIAL | APPROVED |
| 2         |         | AS DRAWN BY CANAM.                                                                          | 8/31/2012 | JAG     |          |
| 3         | 16-0104 | UPDATED TO NEW STANDARD. CH'D DIM WAS .200 +.000 -.003 IS .180. ADDED DIM (5/16-24 UNF-2A). | 8/11/2016 | DEW     | SM       |



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WORK ORDER  
NO. 187269 MWS  
1871-29

|                                                 |                                                        |
|-------------------------------------------------|--------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>                       |                                                        |
| TITLE<br><b>BUTTON HEAD SCREW SWA-3A SWIVEL</b> |                                                        |
| DWG NO.<br><b>SWA3-400</b>                      | REV<br><b>3</b>                                        |
| MAT'L S.S.                                      | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |
| HEAT TREAT                                      | .XXX ± .005 FRACTIONS ± 1/8                            |
| FINISH                                          | .XX ± .01 ANGLES ± 5°                                  |
| SPEC                                            | .X ± .1 SURFACES = 125/✓                               |
| DRAWN BY: CANAM                                 | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R        |
| CHECKED: DUERFELDT                              | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING           |
| OPPS APPR: ANDERSON                             | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009       |
| QA APPR: LINDSAY                                | USED ON MODEL                                          |
| APPROVED: MACKOVJAK                             |                                                        |
| SCALE 4:1                                       | DATE 7/16/1997                                         |

| ASSY QTY | ASSY QTY | B/O | Part #   | UNIT QTY | Description       | Material | B/O INFORMATION OR SPECIFICATIONS                 | PG. |
|----------|----------|-----|----------|----------|-------------------|----------|---------------------------------------------------|-----|
|          |          |     | SWA3-400 | 1        | BUTTON HEAD SCREW | S.S.     | 5/16-24 X 3/8 MCMASTER-CARR #92949A595 (MODIFIED) | 1   |

